

Work Order ID 68433



Page 1

Wednesday, April 13, 2011 11:05:40 AM

Item ID: D412-630-034

Accept



Setup Start



Revision ID:

Stop



Item Name: Heli Access Step RH Folding

Start Date: 4/13/2011 Start Qty: 3.00



Cust Item ID:

Required Date: 4/29/2011 Req'd Qty: 3.00



Customer:

Reference:

Approvals:

Process Plan:

[Signature]

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

IIN D412-630

Rev M

100

0.00



DOCUMENT CONTROL

DC

Memo

0.00

Document Control

Photocopy bluefile & create labels per PPP D412-630-034 CHG003

8/11/11

OK RD 8/11/11

110

0.00



Small Fab

Small Fab

Memo

0.00

Small Fab

Assemble as per dwg D412-630 p.14

Coat all hardware with LPS3 rust inhibitor

A/R LPS3 batch: *1108929*

COAT exposed HARDWARE WITH LPS PROCYON

A/R LPS PROCYON BATCH: _____

ES 4/04/29 (3)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 68433

Wednesday, April 13, 2011 11:05:40 AM



Page 2

Item ID: D412-630-034

Accept



Setup Start



Revision ID:

Stop



Item Name: Heli Access Step RH Folding

Start Date: 4/13/2011 Start Qty: 3.00



Cust Item ID:

Required Date: 4/29/2011 Req'd Qty: 3.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

120

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

8 ul 4/28



130

Pick Kit

0.00



Packaging

Memo

0.00

Packaging

11/4/20 (30) S

140

QC4- 100% Inspect kits for completeness

0.00



QC

Memo

0.00

Quality Control

8 ul 4/28



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 68433

Page 3

Wednesday, April 13, 2011 11:05:40 AM

Item ID: D412-630-034

Accept



Setup Start



Revision ID:

Stop



Item Name: Heli Access Step RH Folding

Start Date: 4/13/2011 Start Qty: 3.00



Cust Item ID:

Required Date: 4/29/2011 Req'd Qty: 3.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150		0.00							
	Packaging								
Packaging	Memo	0.00							
Packaging	Identify and pack for shipping as per PPP D412-630-034								
	Location: <u>119</u>								
	PPP Rev: <u>A</u>								
160		0.00							
	QC21- Final Inspection - Work Order Release								
QC	Memo	0.00							
Quality Control									

11/4/09 SL 30

K 11/04/28

MF
11-04-29

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Wednesday, April 13, 2011 11:05:36 AM

Page 1

Work Order ID: 68433

Parent Item: D412-630-034

Parent Item Name: Heli Access Step RH Folding




Start Date: 4/13/2011

Required Date: 4/29/2011

Start Qty: 3.00

Required Qty: 3.00

Comments: IPP Rev:A New Issue 06-11-08 JLM
 IPP rev B ecn1019, added D2807-041 EC verified by:DD
 IPP rev :C 11.01.06 added route seq ID DD vef:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
AN310C8  Nut		Purchased	No			110	Each	21.0000	2	6			
<div> <div>Location</div> <div>ST324</div> <div>111819</div> </div> <div> <div>Loc Qty</div> <div>21</div> <div>21</div> </div> <div> <div>Loc Code</div> <div></div> <div></div> </div>													
AN3C21A  BOLT		Purchased	No			110	Each	55.0000	2	6			
<div> <div>Location</div> <div>ST352</div> <div>109148</div> <div>117366</div> </div> <div> <div>Loc Qty</div> <div>55</div> <div>35</div> <div>20</div> </div> <div> <div>Loc Code</div> <div></div> <div></div> <div></div> </div>													
AN8C16  Bolt		Purchased	No			110	Each	65.0000	2	6			
<div> <div>Location</div> <div>ST345</div> <div>105969</div> <div>106066</div> </div> <div> <div>Loc Qty</div> <div>65</div> <div>5</div> <div>60</div> </div> <div> <div>Loc Code</div> <div></div> <div></div> <div></div> </div>													

Handwritten signature and date: 4/11/04/26

Handwritten signature and date: 4/11/04/26

Handwritten signature and date: 4/11/04/26

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Wednesday, April 13, 2011 11:05:36 AM

Page 2

Work Order ID: 68433

Parent Item: D412-630-034

Parent Item Name: Heli Access Step RH Folding

Start Date: 4/13/2011

Required Date: 4/29/2011

Start Qty: 3.00

Required Qty: 3.00

D2012-107



Clevis

Manufactured No

110 Each

43.0000

1

3



EB 11/04/26

Location

Loc Qty

Loc Code

WA005

43

62242

3

66811

40

3

D2803-042



Bracket Assembly

Manufactured No

110 Each

5.0000

1

3



EB 11/04/26

Location

Loc Qty

Loc Code

ST149

5

64093

5

B61725 (3x)

D2804-042



Bracket Assembly

Manufactured No

110 Each

7.0000

1

3



EB 11/04/26

Location

Loc Qty

Loc Code

ST150

7

62077

3

66643

4

2

1

D2807-041



Door prop

Manufactured No

110 Each

27.0000

2

6



EB 11/04/26

Location

Loc Qty

Loc Code

ST022

27

60540

2

61891

3

65324

8

66336

14

5

1

Wednesday, April 13, 2011 11:05:36 AM

Shop Packet Print

Page 2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Wednesday, April 13, 2011 11:05:36 AM

Page 3

Work Order ID: 68433

Parent Item: D412-630-034

Parent Item Name: Heli Access Step RH Folding

Start Date: 4/13/2011

Required Date: 4/29/2011

Start Qty: 3.00

Required Qty: 3.00

D2813



Washer

Manufactured No

110 Each 25.0000

2

6



Ep 5/11/04/26

Location

Loc Qty

Loc Code

ST023

25

61051

25

6

D3395-1



Bushing

Manufactured No

110 Each 16.0000

4

12



Ep 5/11/04/26

Location

Loc Qty

Loc Code

ST052

16

60861

16

8

4

B 68491
B65841 (3x)

D3562-042



Step Assembly, RH

Manufactured No

110 Each 0.0000

1

3



Ep 5/11/04/26

MS21043-3



Nut

Purchased No

110 Each 1,023.000

1

12



Ep 5/11/04/26

Location

Loc Qty

Loc Code

FG

80

103691

80

FP-B

-5

112314

-5

ST301

948

112314

948

2

MS24665-302



Cotter Pin

Purchased No

110 Each 22.0000

2

6



Ep 5/11/04/26

Location

Loc Qty

Loc Code

ST309

22

113644

22

6

Wednesday, April 13, 2011 11:05:37 AM

Shop Packet Print

Page 3

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Wednesday, April 13, 2011 11:05:37 AM

Page 4

Work Order ID: 68433

Parent Item: D412-630-034

Parent Item Name: Heli Access Step RH Folding

Start Date: 4/13/2011

Required Date: 4/29/2011

Start Qty: 3.00

Required Qty: 3.00

MS24693-C280

Purchased

No

110

Each

39.0000

2

6



Screw

Location

Loc Qty

Loc Code

ST310

30

115594

30

ST318

9

111279

9

NAS1515H3

Purchased

No

110

Each

97.0000

6

18



Washer

Location

Loc Qty

Loc Code

ST277

97

115935

2

116373

95

NAS1515H5L

Purchased

No

110

Each

124.0000

4

12



WASHER

Location

Loc Qty

Loc Code

FG

40

103691

40

ST277

84

111359

84

NAS1515H8

Purchased

No

110

Each

283.0000

4

12



Washer

Location

Loc Qty

Loc Code

ST278

283

111275

83

111411

200

Wednesday, April 13, 2011 11:05:37 AM

Shop Packet Print

Page 4

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Wednesday, April 13, 2011 11:05:37 AM

Page 5

Work Order ID: 68433

Parent Item: D412-630-034

Parent Item Name: Heli Access Step RH Folding

Start Date: 4/13/2011

Required Date: 4/29/2011

Start Qty: 3.00

Required Qty: 3.00

AN44C7A

Purchased

No

130

Each

80.0000

1



Eyebolt

Location

Loc Qty

Loc Code

ST362

80

109013

40

111308

40

AN4C10A

Purchased

No

130

Each

84.0000

1



Bolt

Location

Loc Qty

Loc Code

ST356

84

111295

4

112243

50

114523

30

AN4C15A

Purchased

No

130

Each

54.0000

2



Bolt

Location

Loc Qty

Loc Code

ST358

54

115457

8

115936

46

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Wednesday, April 13, 2011 11:05:37 AM

Page 6

Work Order ID: 68433

Parent Item: D412-630-034

Parent Item Name: Heli Access Step RH Folding

Start Date: 4/13/2011

Required Date: 4/29/2011

Start Qty: 3.00

Required Qty: 3.00

AN4C6A

Purchased

No

130

Each

345.0000

1

3



Bolt

Location

Loc Qty

Loc Code

FG

4

103344

4

ST306

50

117313

50

ST356

291

115016

14

116003

127

116400

50

116704

100

AN5C15A

Purchased

No

130

Each

43.0000

2

6



Bolt

Location

Loc Qty

Loc Code

ST339

43

111819

43

D2806-1

Manufactured

No

130

Each

16.0000

2

6



Bushing

Location

Loc Qty

Loc Code

ST022

16

46609

6

64074

10

Wednesday, April 13, 2011 11:05:37 AM

Shop Packet Print

Page 6

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Wednesday, April 13, 2011 11:05:37 AM

Page 7

Work Order ID: 68433

Parent Item: D412-630-034

Parent Item Name: Heli Access Step RH Folding

Start Date: 4/13/2011

Required Date: 4/29/2011

Start Qty: 3.00

Required Qty: 3.00

D2806-3 Manufactured No

130 Each

17.0000

2

6



Bushing

Location

Loc Qty

Loc Code

ST022

17

46737

7

64075

10

D2810-5 Manufactured No

130 Each

7.0000

1

3



Strut

Location

Loc Qty

Loc Code

ST265

7

52034

1

64081

6

D3396-1 Manufactured No

130 Each

38.0000

2

6



Spacer

Location

Loc Qty

Loc Code

ST052

38

46748

38

MS21043-4 Purchased No

130 Each

639.0000

4

12



Nut

Location

Loc Qty

Loc Code

FG

40

104603

40

ST301

599

114523

3

116188

296

116549

300

Wednesday, April 13, 2011 11:05:37 AM

Shop Packet Print

Page 7

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Wednesday, April 13, 2011 11:05:37 AM

Page 8

Work Order ID: 68433

Parent Item: D412-630-034

Parent Item Name: Heli Access Step RH Folding

Start Date: 4/13/2011

Required Date: 4/29/2011

Start Qty: 3.00

Required Qty: 3.00

MS21043-5

Purchased

No

130

Each

561.0000

3



Nut

Location

Loc Qty

Loc Code

FG

20

101418

20

ST301

541

~~112314~~

441

116548

100

NAS1515H4

Purchased

No

130

Each

97.0000

7



Washer

Location

Loc Qty

Loc Code

ST277

97

~~111525~~

47

116169

50

NAS1515H5

Purchased

No

130

Each

178.0000

7



Washer

Location

Loc Qty

Loc Code

FG

40

103286

20

103691

20

ST277

138

109430

138

Wednesday, April 13, 2011 11:05:37 AM

Shop Packet Print

Page 8

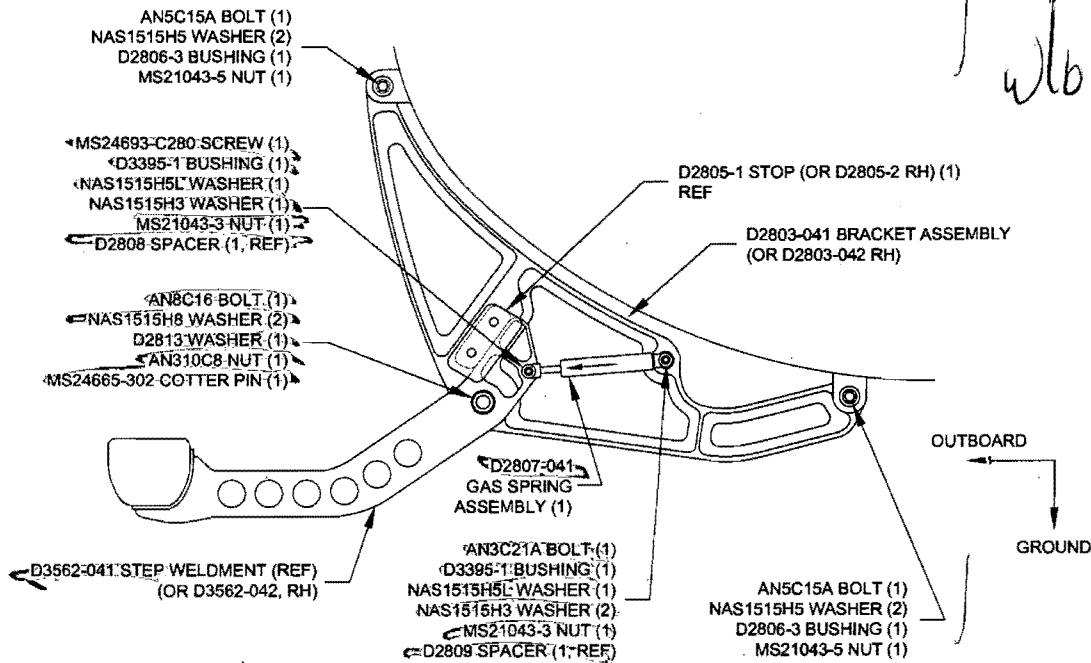
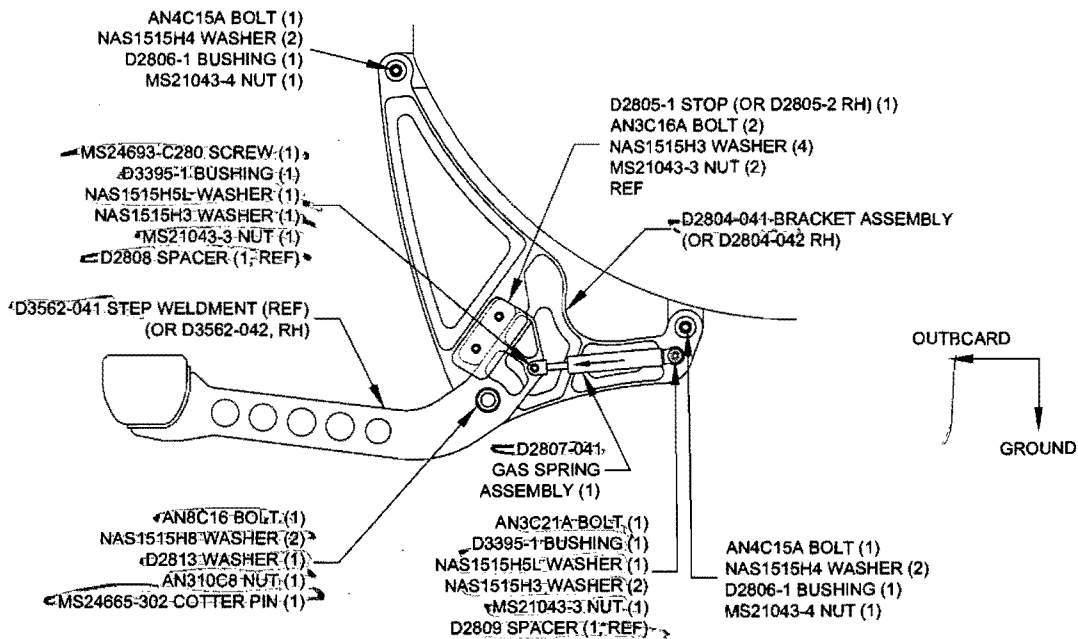
W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

D412-630-033/-034 Heli-Access-Step™ Installation**FIGURE 25-13: STA 84.29 for D412-630-033/-034 Heli-Access-Step™ Installation
(View rotated 90° CW)****FIGURE 25-14: STA 155.06 for D412-630-033/-034 Heli-Access-Step™ Installation
(View rotated 90° CW)**

• COPYRIGHT © 2006 BY DART AEROSPACE LTD. •
THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED
OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.

25-00-00

D3562-1, MAKE FROM EXTRUSION D2622

APPLY BLACK ANTI-SKID ON TOP SURFACE TO BOTTOM OF TOP RADIUS

D3560-043 ARM WELDMENT

D3560-041 ARM WELDMENT

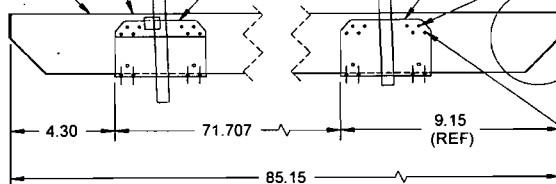
TRANSFER DRILL #30 DEBURR & TOUCH UP HOLES WITH CHEMICAL CONVERSION COAT BEFORE RIVETING (32 PLACES PER STEP)

D3560-042 ARM WELDMENT

D3560-044 ARM WELDMENT

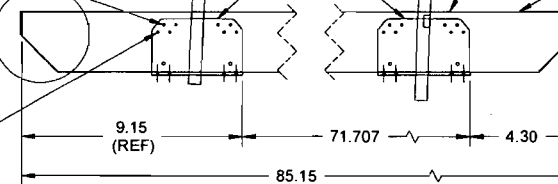
D3562-1, MAKE FROM EXTRUSION D2622

APPLY BLACK ANTI-SKID ON TOP SURFACE TO BOTTOM OF TOP RADIUS



MEASURED BEFORE END CAPS WELDED IN PLACE

FWD



MEASURED BEFORE END CAPS WELDED IN PLACE

FWD

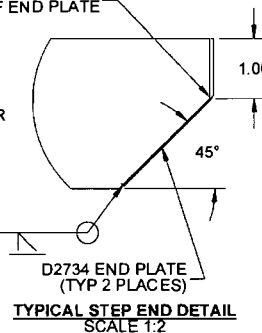
REFER TO STEP END DETAIL

INSTALL MS20600AD4W5 RIVET (32 PLACES PER STEP)

ROUND CORNER OF EXTRUSION TO MATCH BEND RADIUS OF END PLATE

NOTE: ALL WELDS SHALL BE 100% VISUALLY INSPECTED BY A QUALIFIED INSPECTOR PER DART QSI 004

REFERENCE ONLY



D3562-041 LH STEP ASSEMBLY

D3562-042 RH STEP ASSEMBLY

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH:
 - i) CHEMICAL CONVERSION COAT STEP EXTRUSION PER DART QSI 005 4.1 BEFORE ASSEMBLY
 - ii) POWDER COAT ASSEMBLY GLOSS WHITE (4.3.5.1) OR GREY SANDTEX (4.3.5.6) OR BLACK SANDTEX (4.3.5.7) OR GREEN SANDTEX (4.3.5.8) PER DART QSI 005 4.3
 - iii) BLACK ANTI-SKID PAINT PER DART QSI 005 4.4
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 8.79 lbs
- 8) INSTALL ARM WELDMENTS WITH A LAYER OF MAGNOBOND 6398 BETWEEN THE ARM WELDMENT AND STEP EXTRUSION. FILL ANY TOOLING HOLES WITH MAGNOBOND 6398. CLEAN OFF EXCESS BEFORE POWDER COATING.
- 9) WELDING: PER DART QSI 004

QTY -041	QTY -042	P/N	DESCRIPTION
X	X	D3562-041	LH STEP ASSEMBLY
		D3562-042	RH STEP ASSEMBLY
1		D3560-041	ARM WELDMENT
	1	D3560-042	ARM WELDMENT
1		D3560-043	ARM WELDMENT
	1	D3560-044	ARM WELDMENT
32	32	MS20600AD4W5	RIVET
2	2	D2734	END PLATE

E	ADD QTY (2) TO D2734 END PLATE ON D3562-042	PH	08.01.11
D	REMOVE D2808 SPACER NOTE; REDRAWN IN SOLIDWORKS	DC	07.11.16
C	NOW MAGNOBOND, ADD D2808, REMOVE 4 RIVETS	CP	07.06.19
B	ARMS NOW RIVETED TO STEP	CP	07.01.15
A	NEW ISSUE	CP	06.09.26
REV.	DESCRIPTION	BY	DATE

DESIGN	90	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	KE	DRAWING NO.	REV. E
MFG. APPR.		D3562	SHEET 1 OF 1
APPROVED		TITLE	SCALE
DE APPR.		STEP ASSEMBLY	1:5
DATE	08.01.11	COPYRIGHT © 2006 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

REFERENCE ONLY

Qty -033	Qty -034	Qty -243	Qty -244	Part Number	Description
X				D412-630-033	HELI-ACCESS-STEP™ LH (FOLDING)
	X			D412-630-034	HELI-ACCESS-STEP™ RH (FOLDING)
1		X		D412-630-243	STEP ASSEMBLY LH
	1		X	D412-630-244	STEP ASSEMBLY RH
		1	1	D2012-107	CLEVIS
		1		D2803-041	STA 84 BRACKET ASSEMBLY LH
			1	D2803-042	STA 84 BRACKET ASSEMBLY RH
		1		D2804-041	STA 155 BRACKET ASSEMBLY LH
			1	D2804-042	STA 155 BRACKET ASSEMBLY RH
2	2			D2806-1	BUSHING
2	2			D2806-3	BUSHING
		2	2	D2807-041	GAS SPRING ASSEMBLY (WAS D2807)
1	1			D2810-5	STRUT
		2	2	D2813	WASHER
		1		D3562-041	STEP WELDMENT LH
			1	D3562-042	STEP WELDMENT RH
		4	4	D3395-1	BUSHING
2	2			D3396-1	SPACER
		2	2	AN3C21A	BOLT
1	1			AN4C6A	BOLT
1	1			AN4C10A	BOLT
2	2			AN4C15A	BOLT
1	1			AN44-C7A	EYEBOLT
2	2			AN5C15A	BOLT
		2	2	AN8C16	BOLT
		2	2	AN310C8	NUT
		2	2	MS24665-302	COTTER PIN (OR AN380C3-4)
		6	6	NAS1515H3	WASHER
7	7			NAS1515H4	WASHER
7	7			NAS1515H5	WASHER
		4	4	NAS1515H5L	WASHER
		4	4	NAS1515H8	WASHER
		4	4	MS21043-3	NUT
4	4			MS21043-4	NUT
3	3			MS21043-5	NUT
		2	2	MS24693-C280	SCREW (OR MS24694-C565)

